

Work Order ID 62706

Wednesday, October 06, 2010 3:21:07 PM



Page 1

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 10/6/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
304 .040	1-Cut as per Dwg D3535 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							
	JM-03								
	A1272								

1810-10-18

13

1810-10-18

13

10/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62706

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Page 2

Item ID: D3535-23

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Revision ID:

Stop



Item Name: Wearshoe

Start Date: 10/6/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326
joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23

GS 10/10/20 (13)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

13 *10/10/20*

150

Grey Sandtex (Ref: 4.3.5.6) per OSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *8:55* FINISH TIME: *8:25* OVEN TEMPERATURE:

M 112588

10-10-22

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Stop



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Start Date: 10/6/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

27M

10/10/22

X13

0



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

FR-21

0.00

10-10-22

13



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/22

mf

10-10-22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 3:21:11 PM

Page 1

Work Order ID: 62706



Parent Item: D3535-23



Parent Item Name: Wearshoe



Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	108.6987	1.3615	17.19789	18.		
304/316 .040 Sheet											180-10-18		

Location

Loc Qty

Loc Code

MAT	85.9522	
114574	10.6522	
115762	75.3	
MAT20	22.7465	
112885	2.7475	
113062	0.699	
115440	19.3	

115762

13

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62706
Description: Wearshoe		Part Number:	D3535-23
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.887	✓		V B02	
2.000	+/-0.010	2.000	✓		V	
4.750	+/-0.010	4.750	✓		V	
9.500	+/-0.010	9.500	✓		T B01	
14.250	+/-0.010	14.250	✓		T	
17.750	+/-0.010	17.750	✓		T	
23.140	+/-0.010	23.140	✓		T	
28.530	+/-0.010	28.530	✓		T	
33.920	+/-0.010	33.920	✓		T	
39.310	+/-0.010	39.310	✓		T	
44.700	+/-0.010	44.700	✓		T	
48.200	+/-0.010	48.200	✓		T	
52.850	+/-0.010	52.850	✓		T	
Ø0.188	+0.005/-0.001	.193	✓		V	
48.00	+/-0.030	48.00	✓		T	
39.00	+/-0.030	39.00	✓		T	
32.00	+/-0.030	32.00	✓		T	
24.00	+/-0.030	24.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
8.00	+/-0.030	8.000	✓		V	
6.00	+/-0.030	5.999	✓		V	
0.300	+/-0.010	.305	✓		V	
0.300	+/-0.010	.306	✓		V	
0.038	+/-0.010	.036	✓		V	

Measured by:	RB	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	10-10-18	Date:	10/10/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	[Signature]

W/O:		WORK ORDER CHANGES					
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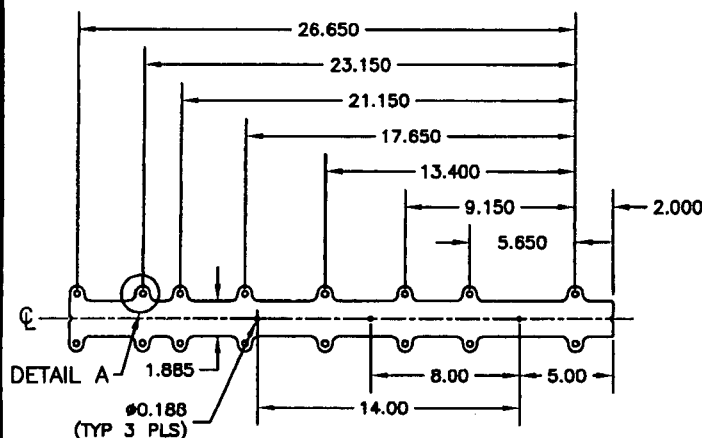
NOTE: Date & initial all entries

DART

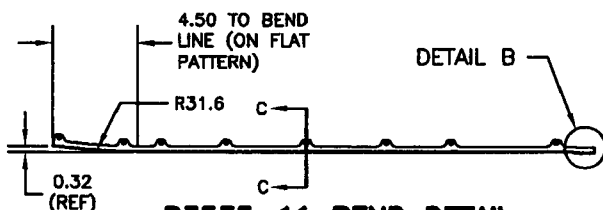
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07.04.24

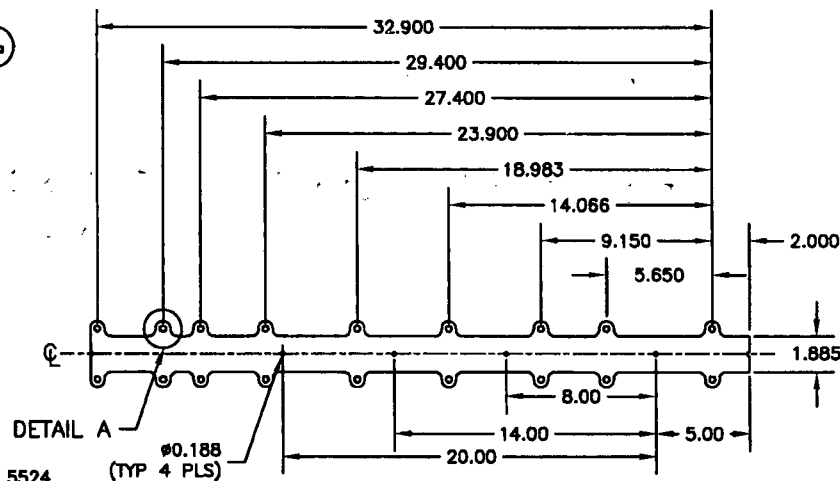
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO COMMENT
WITH THE
WORK ORDER
NO. 62704
BS10-10-04



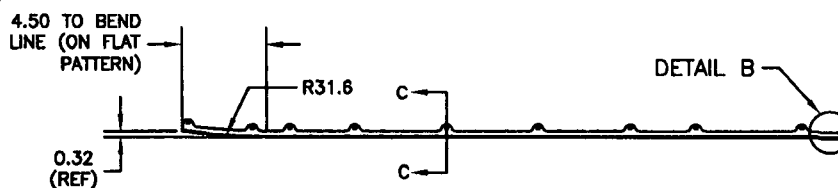
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	TITLE	DRAWING NO.	REV. B
CB	PH	WEARSHOE	D3535	SHEET 1 OF 7
CHECKED	APPROVED	DATE	DATE	SCALE
		07.04.17	06.10.25	1:10
A		NEW ISSUE		
B		MOVE TAB OUTBOARD, ADD AMS SPEC		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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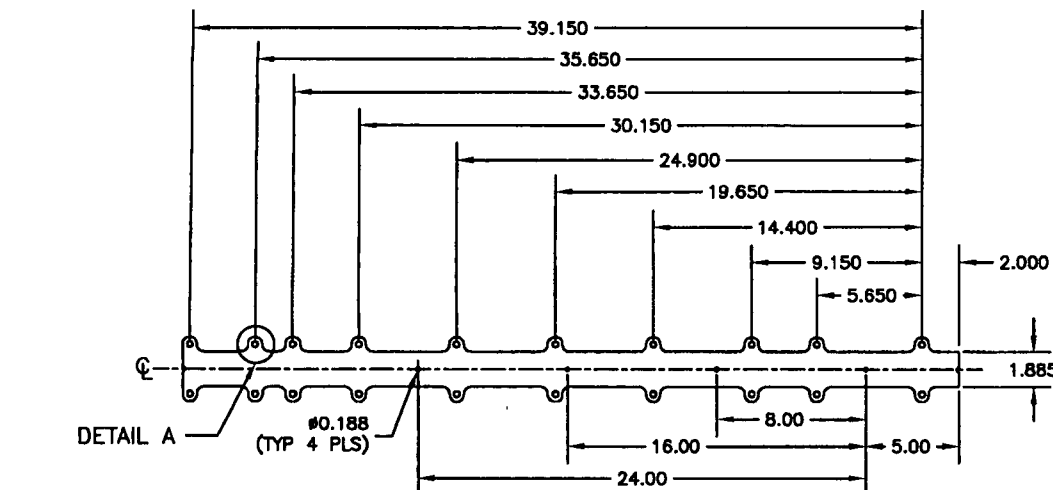
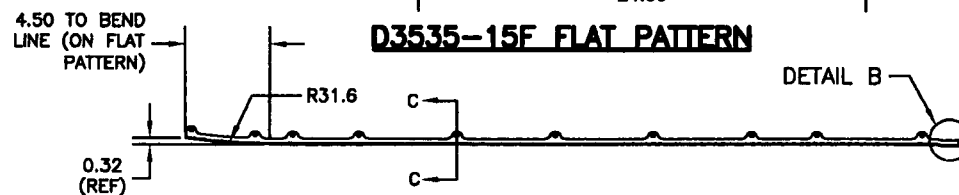
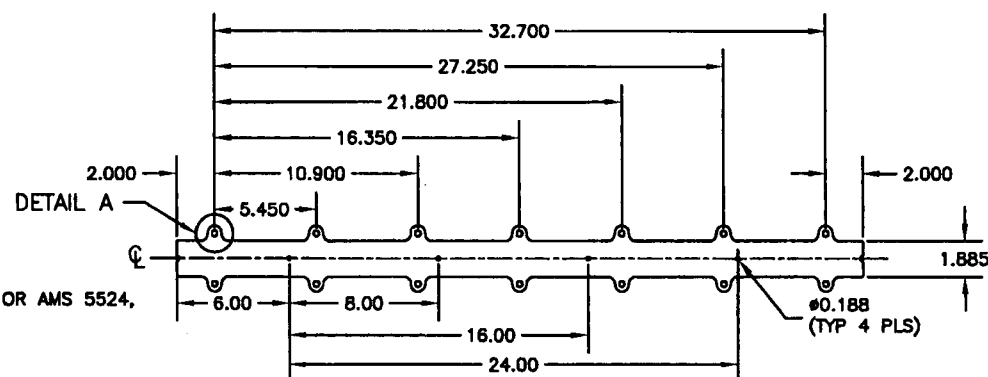
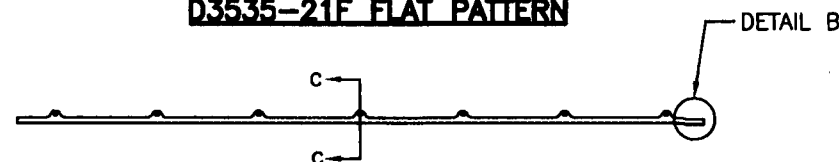
NOTE: Date & initial all entries

DART

RELEASED

07.04.24

w/042706

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
		SHEET 2 OF 7
		REV. B

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

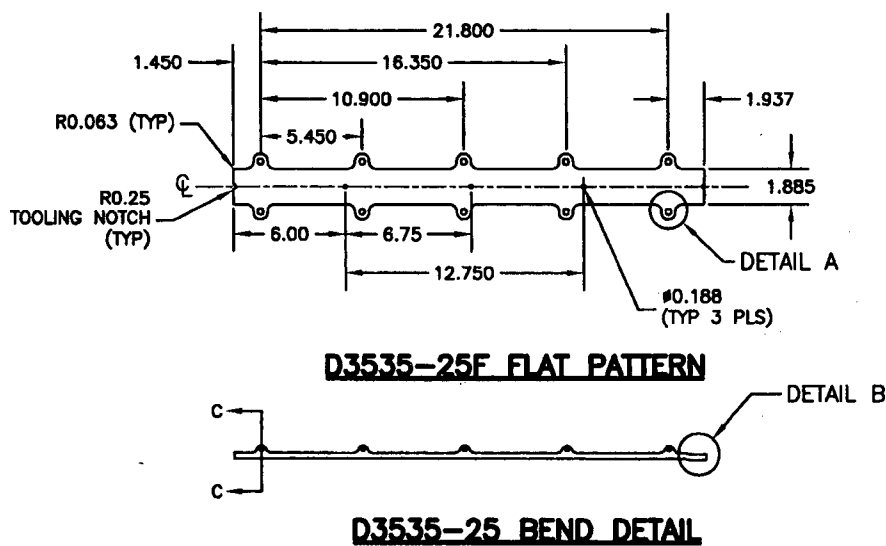
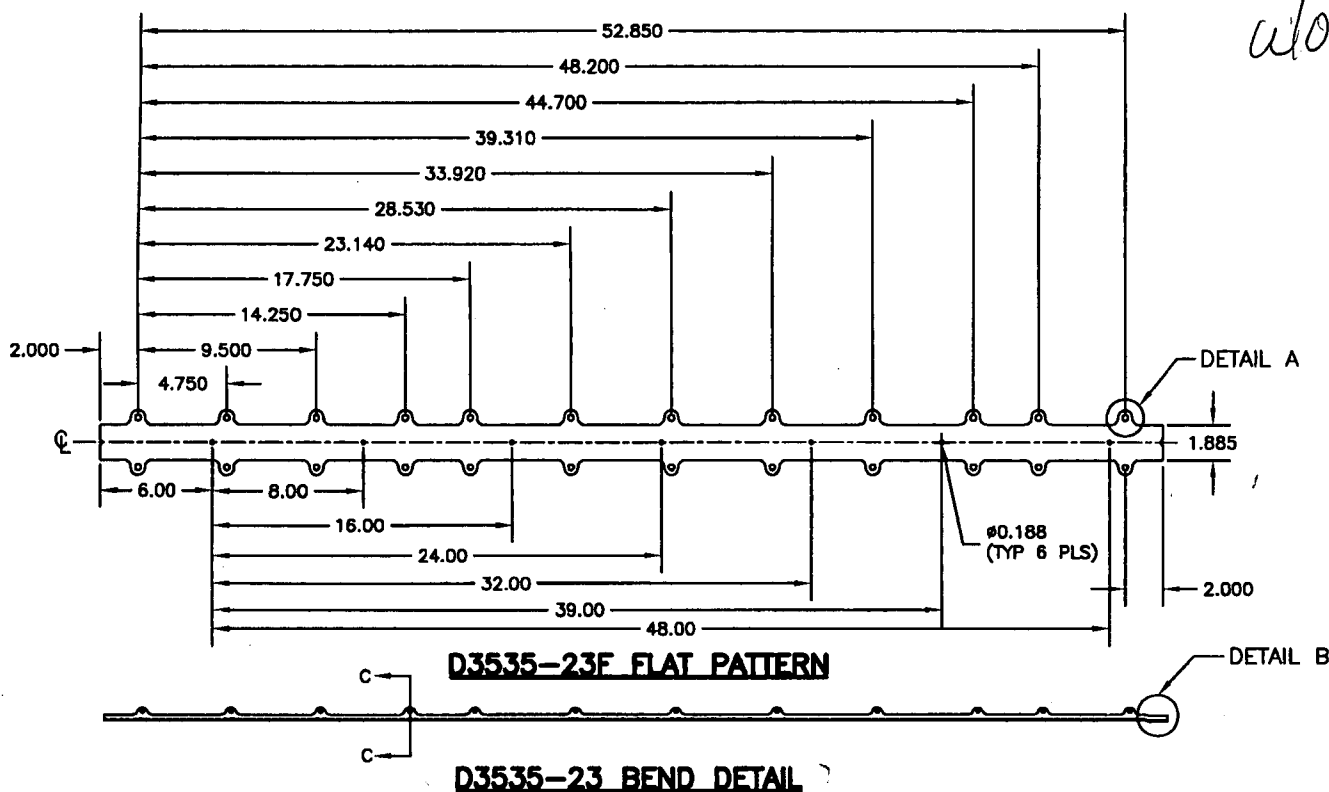
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DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		REV. B	SHEET 3 OF 7	SCALE 1:10

RELEASED

07.04.24

WLO 62704



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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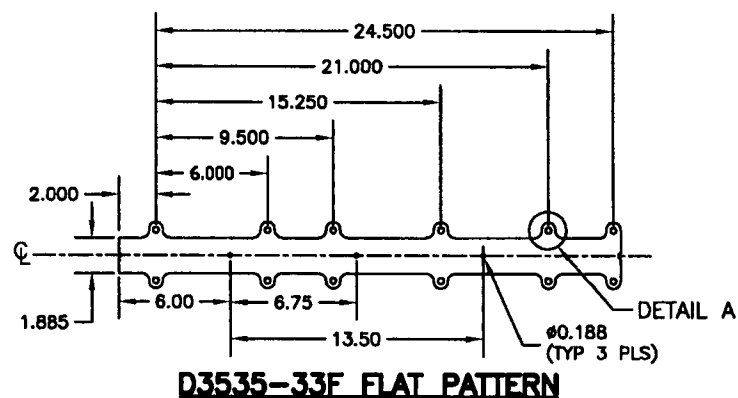
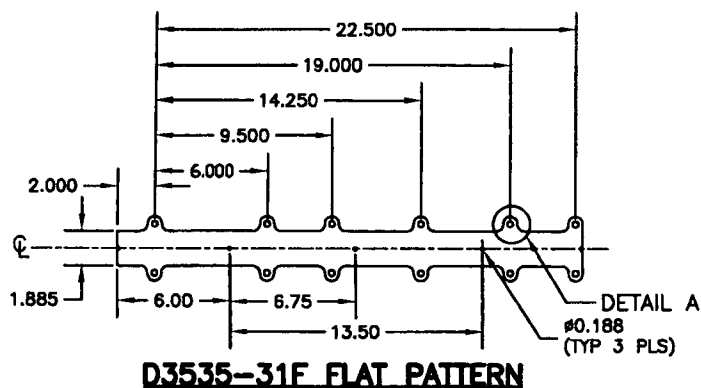
NOTE: Date & initial all entries

DART

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07.04.24

WLO 62766



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REV. B
			WEARSHOE	SHEET 4 OF 7
				SCALE 1:10

W/O:		WORK ORDER CHANGES					
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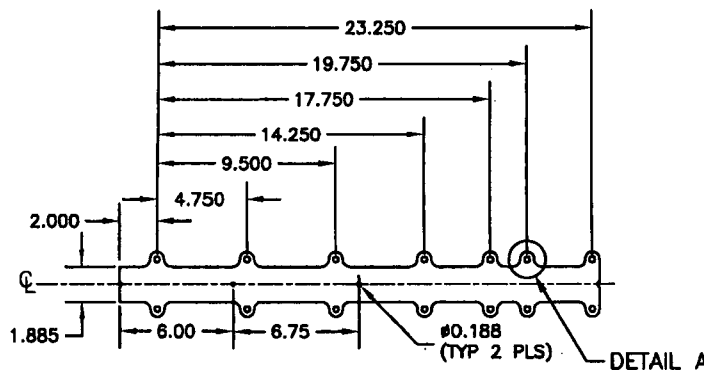
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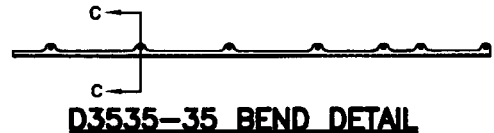
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W/C 62706

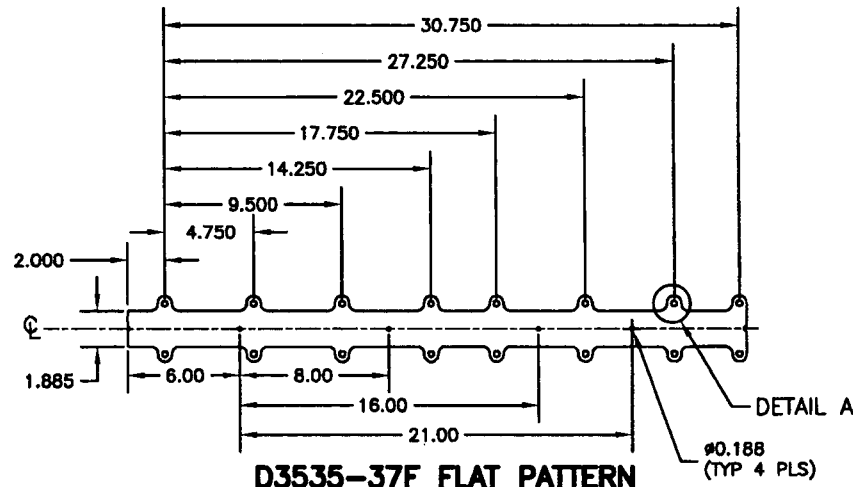
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		REV. B	SHEET 5 OF 7	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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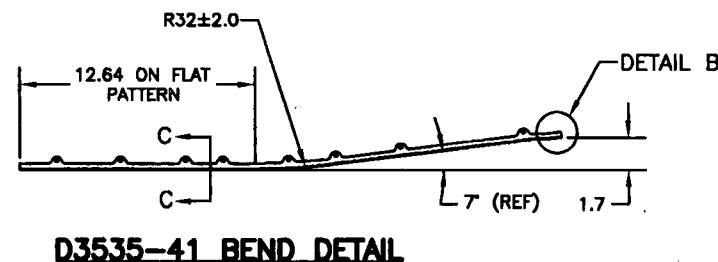
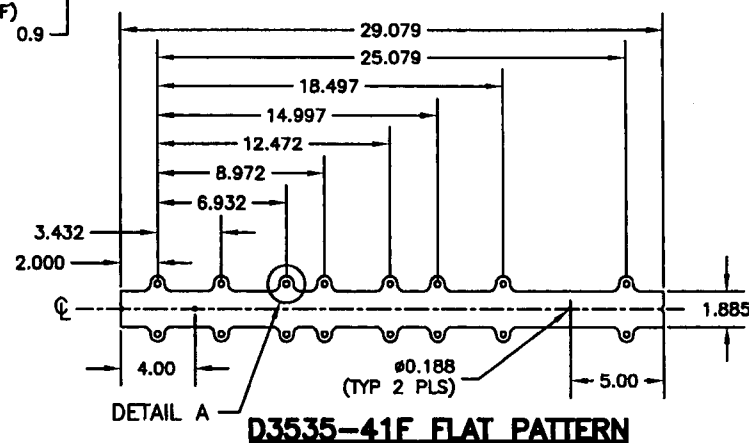
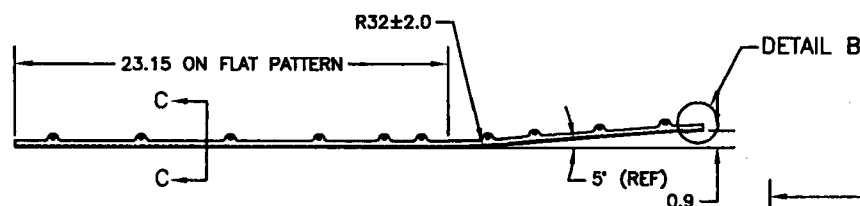
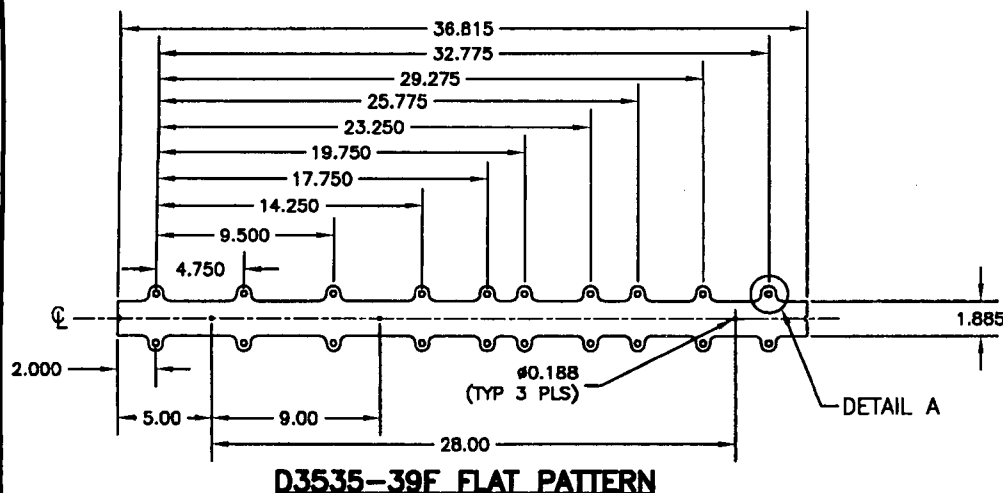
NOTE: Date & initial all entries

DART

RELEASED

07.04.17

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE 1:10

**NOTES**

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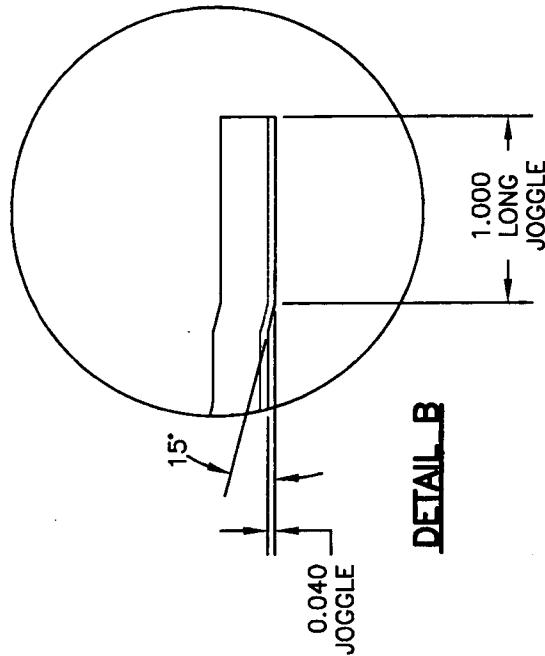


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

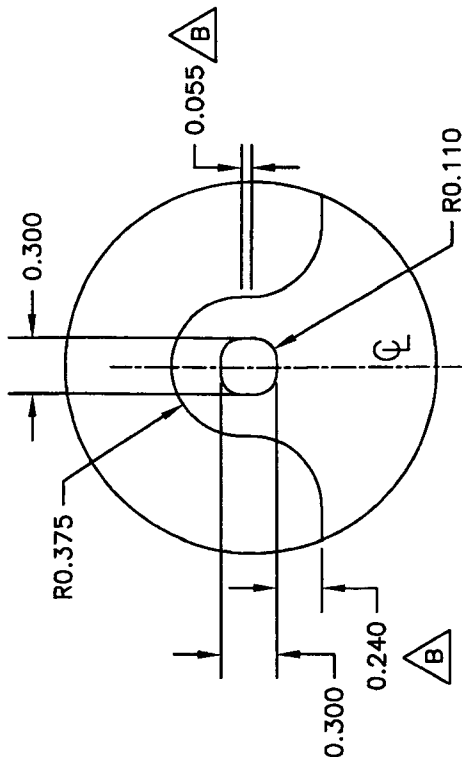
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07.04.24

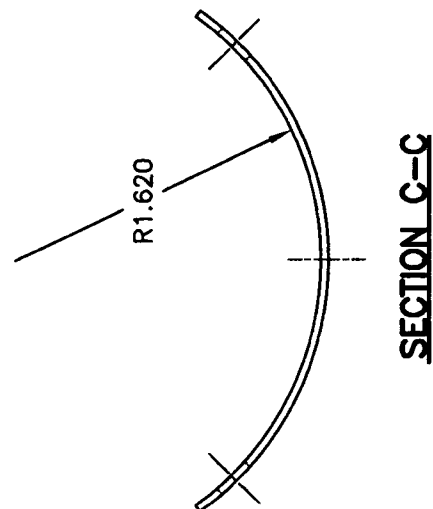
W/O 62706



DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries